

# Work Order ID 54213

December 03, 2009 9:21:59 AM



Page 1

Item ID: D205-596-105

Accept



Setup Start



Revision ID: B

Stop



Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-12-3*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D205-596

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG002

*10/01/02*

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend as per Dwg D2889 using CNC bender program

*MS 09-12-15*

120

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

*u/w*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

*mark cut lines at bottom of loose line => 808/12/15*

Memo

0.00



140



Crosstubes

Crosstubes

Crosstubes

Memo

1-Cut as per Dwg D205-596-105  
2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

0.00

0.00

150



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

*2) 810/01/05*

*AWM 10-01-04*



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Start Date: 12/3/2009 Start Qty: 1.00



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Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Crosstubes Chemical Conversion	0.00							
HandFXtube	Memo	0.00				1	-	-	10-01-07
Hand Finishing Crosstubes									
170	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside and outside with Immron per QSI 005 4.2								
180	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control									

10/01/07 (1)

RT 10-01-11 (1)

W/O:		WORK ORDER CHANGES					
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Start Date: 12/3/2009 Start Qty: 1.00

Required Date: 12/22/2009 Req'd Qty: 1.00

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Crosstubes	Crosstubes	0.00							
Crosstubes	Memo 1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 2- Apply magnobond 6398 as per dwg D205-596-105 Magnobond 6398 Batch: 112417 3- Inst Torque: ml 10/1/12	0.00							
200  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
210  Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D205-596-105 Location: _____ PPP Rev: _____	0.00							

W/O:		WORK ORDER CHANGES					
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Required Date: 12/22/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/01/15  
MF 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

December 03, 2009 9:21:59 AM

Page 1  
3

Work Order ID: 54213

Parent Item: D205-596-105RevB

Parent Item Name: Crosstube Fwd Extended


Comments:

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6005-180RevA		Manufactured	No			110	Each	11.0000	1.0000			
												
Crosstube Material												

(X) MB 09-12-15 ✓

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

LG

11

39734

11

D2893-1RevB

Manufactured

No

190

Each

72.0000

2.0000



2.75 Support



(X)

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

72

25657

6

47109

2

47637

16

51775

19

53125

19

53340

10

m 10/01/11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist\*Print

December 03, 2009 9:21:59 AM

Work Order ID: 54213



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			190	Each	201.0000	4.0000			



Clamp(per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	201
107456	2
108111	3
108975	17
109181	42
109644	10
111282	4
111429	1
112495 x 1	22
112919 x 3	25
113281	25
113282	50

*10/01/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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December 03, 2009 9:21:59 AM

Work Order ID: 54213



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3595-063-450RevA		Manufactured	No			190	Each	196.9689	4.0000			
RUBBER CUSHION												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	92	
52447	92	
Main Warehouse		
ST	104.9689	
38959	2	
43210	2.59	
46465	0.3789	
53775	100	

*m/l 10/01/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6005-180  
FINISHED LENGTH =  $134.40 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR  
SHORTER (MS21920-24) CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A  
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

STANDARD BY  
RETURN  
ENGINEER  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54243

109123

DEO ATTACHED

RELEASED  
06-01-16

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D205-596-105	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY, HI-HI FWD	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

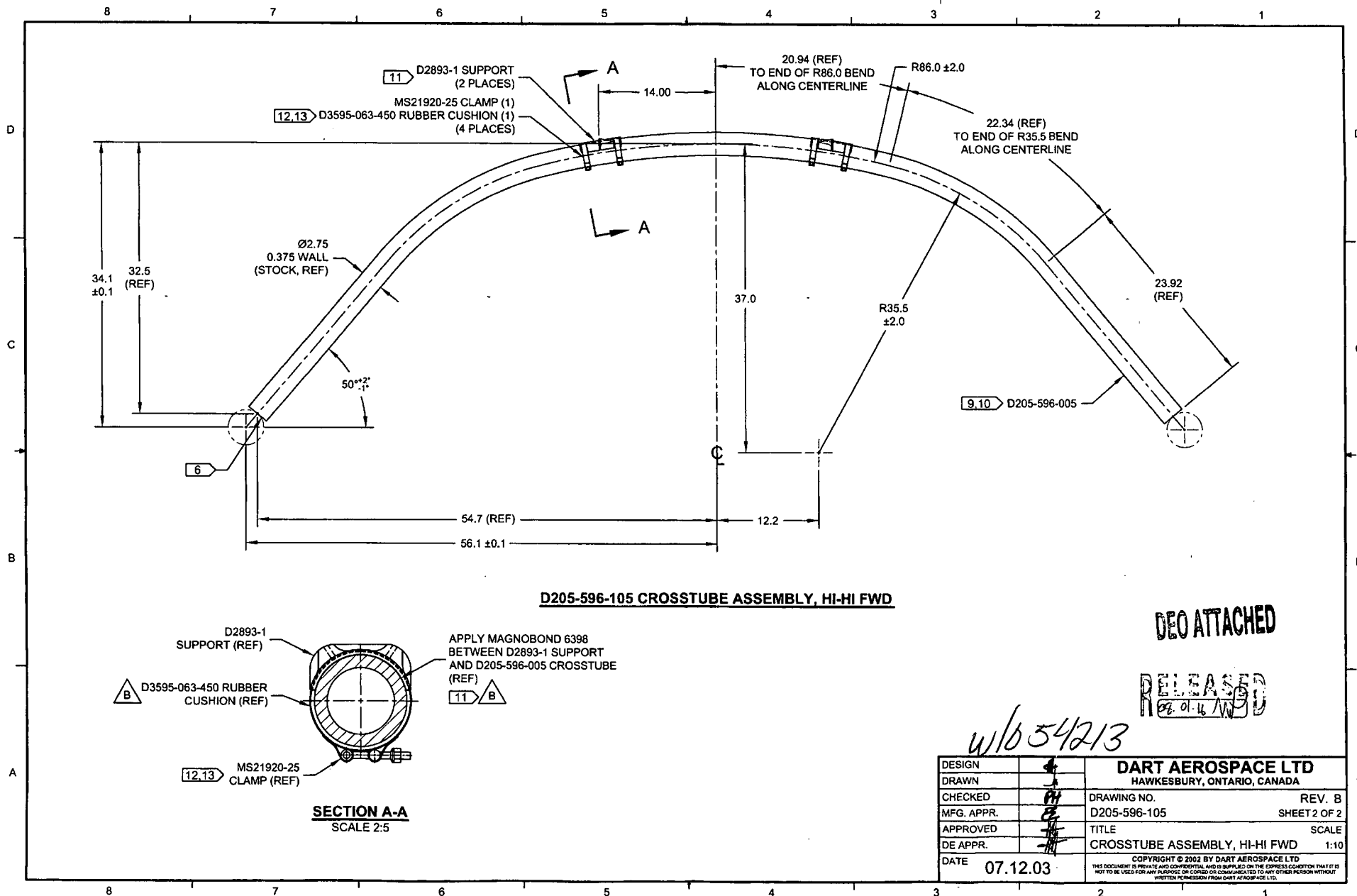
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DRAWING NO. D205-596-105	TITLE CROSSTUBE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D205-596-105-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>MM</i>	APPROVED <i>W/D</i>		DE APPR. <i>W/D</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09/06/22	DATE 09/06/22		DATE 09.06.22		

*w/o 54213*

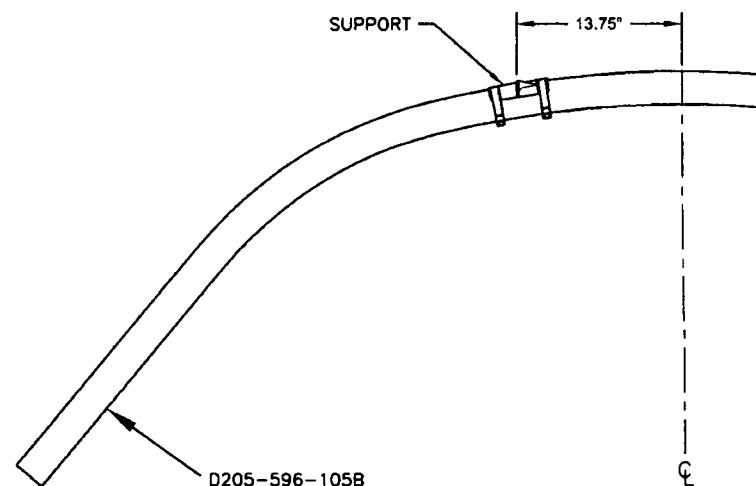
**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D205-596-105B	CROSSTUBE ASSEMBLY (214 HI-HI FWD)

THE D205-596-105B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-105 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-105 CROSSTUBE.

**RELEASED**  
*09/06/22*



**FIGURE 1 - SUPPORT INSTALLATION**

W/O:		WORK ORDER CHANGES					
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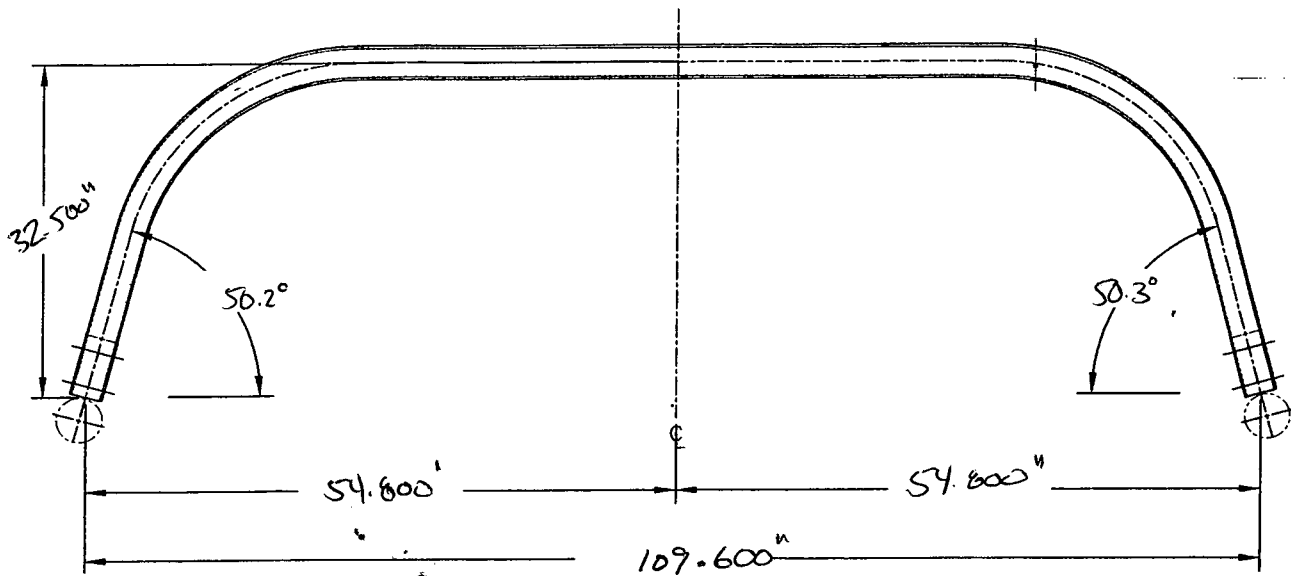
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DART AEROSPACE LTD		Work Order:	54213
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments
* tube is @ max. <del>min.</del> <del>max.</del> <del>min.</del> <del>max.</del> on width

QC15 Inspection	S
Date	08/02/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	

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